

Work Order ID 53962

November 24, 2009 8:27:05 AM



Ship Friday

Page 1

Item ID: D407-559-113

Accept



Setup Start



Revision ID:

Item Name: Bearpaw, Large

Stop



Start Date: 11/24/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 11/27/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-11-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D206-559	K

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPPD407-559-113 CHG001

5 07/11/26

10/11/24 BG 09/11/24

160 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

12/14/26 (3)

170 0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

2/8 07/11/26

11/15/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD407-559-113
Location: _____*Per 11/26/09*

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/11/26/09**MF 09-11-26*

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Picklist Print

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Work Order ID: 53962

Parent Item: D407-559-113

Parent Item Name: Bearpaw, Large

Comments: IPP RevA: New issue DD 09.10.29 verified by:EC
IPP RevB: ECN09-698p DD 09.11.03 verified by:EC
as per revision K DD 09.11.24 verified by:EC



IPP RevC:

Start Date: 11/24/2009

Required Date: 11/27/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2274RevF-20X 		Manufactured	No			160	Each	409.0000	80.0000	✓		
Radius Block												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

409

22494

0

23174

0

52644

409

D3456-1RevA 2X

Manufactured No

160

Each

155.0000

8.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

7

25701

7

Main Warehouse

ST

148

51653

148

D4010-041 2X

Manufactured No

160

Each

0.0000

8.0000

Bearpaw Assembly

D4011-1 2X

Manufactured No

160

Each

0.0000

32.0000

Clamp, Short

52644

51653

B53815 +8 CAD 11-26

53832 PC914/20(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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as per revision K DD 09.11.24 verified by:EC

IPP RevC:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
S ₊ D4011-3 12P		Manufactured	No			160	Each	0.0000	8.0000			
										53833		
Clamp, Long												
S ₊ D4011-5 8P		Manufactured	No			160	Each	0.0000	32.0000			
										53834		
Clamp, Short												
S ₊ D4012-1 10X		Manufactured	No			160	Each	0.0000	40.0000			
										53835		
Cushion												
S ₊ AN4C10A 12P		Purchased	No			160	Each	138.0000	8.0000			
Bolt												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

138

101189

5

106302

33

111295

50

112243

50

106302

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Shop Packet Print

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IPP RevC:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4C13A } 4X BOLT		Purchased	No			160	Each	95.0000	16.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	95	
105289	3	
106785	12	
108084	50	
110159	30	

M108084 3X
110159 13X

AN4C15A } 8X Bolt	Purchased	No				160	Each	99.0000	32.0000			
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Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	99	
103915	1	
111819	98	

M111819

AN4C17A } 8X BOLT	Purchased	No				160	Each	0.0000	32.0000			
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M113228

PC9/11/26 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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IPP RevC:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21043-4		Purchased	No			160	Each	1,341.000	80.0000			
Nut											11/26/09	(4)

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	40	
104603	40	
Main Warehouse		
ST	1301	
112243	2	
112314	499	
112492	300	
113064	500	

11/23/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-15A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						18	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER
2		2					QS200M44S	CLAMP

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